

Date: Thursday, 6/5/2008 1:05:15 PM
 User: David Duval

Process Sheet

Customer : CU-DAR001 Dart Helicopters Services	Drawing Name : ARM
Job Number : 05030	
Estimate Number : 13350	
P.O. Number :	Part Number : D35891
This Issue : 6/5/2008 S.O. No. :	Drawing Number : D3589 PROTO 08.06.05
Prsht Rev. : NC	Project Number : VR0004
First Issue : / / Type : R & D SM/MED FAB	Drawing Revision : PROTO
Previous Run :	Material :
Written By : <u>08/06/05</u>	Due Date : 6/12/2008 Qty: 2 Um: Each
Checked & Approved By :	
Comment : Est Rev:A 08-05-29 new issue DD verified by:EC	

Additional Product

PROTOTYPE

Job Number:



FOR ENGINEERING USE ONLY

Seq. #:	Machine Or Operation:	Description :
---------	-----------------------	---------------

1.0	M304TR0375W065	304 RD Tube .375 x .065W
-----	----------------	--------------------------



Comment: Qty.: 1.6520 f(s)/Unit Total : 3.3039 f(s)

304 RD Tube .375 x .065W

batch: M18993

FF 08-06-05

②

2.0	SMALL FAB 1	SMALL & MEDIUM FAB RESOURCE 1
-----	-------------	-------------------------------



Comment: SMALL & MEDIUM FAB RESOURCE 1

1- cut D3589-1 as per dwg D3589

2- deburr both ends as per dwg D3589

FF 08-06-05

②

3.0	QC5	INSPECT WORK TO CURRENT STEP
-----	-----	------------------------------

ENGINEERING
APPROVAL

08.06.09

Comment: INSPECT WORK TO CURRENT STEP

08-06-06

4.0	PACKAGING 1	PACKAGING RESOURCE #1
-----	-------------	-----------------------



FOR ENGINEERING USE ONLY

Comment: PACKAGING RESOURCE #1

Identify and Stock

Location: _____

08-06-06

5.0	QC21	FINAL INSPECTION/W/O RELEASE
-----	------	------------------------------



Comment: FINAL INSPECTION/W/O RELEASE

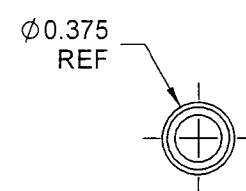
08.06.09 Prototype

Job Completion

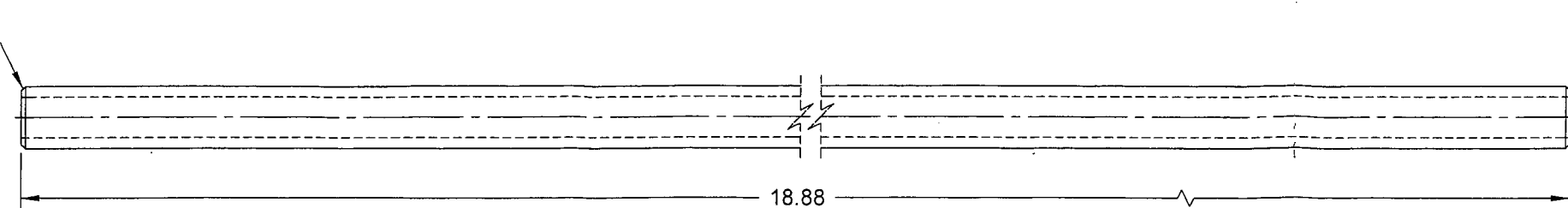


charge to W/p #00224

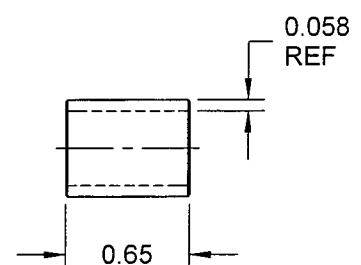
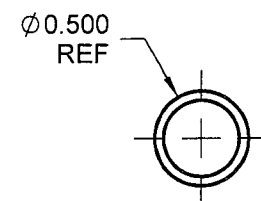
mf 08-06-13



0.03 X 45°
CHAMFER
2 PL

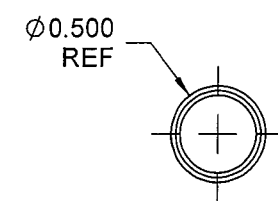


D3589-1 ARM

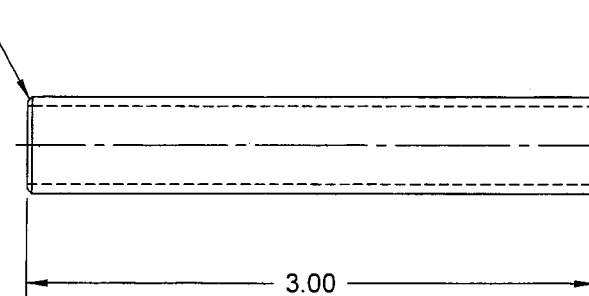


D3589-3 ARM GUIDE

Qty 8



0.03 X 45°
CHAMFER
2 PL



D3589-5 LATCH GUIDE

D3589-1/-3/-5 NOTES:

- 1) MATERIAL: AISI 304/316 STAINLESS STEEL SEAMLESS ROUND TUBING
D3589-1: 0.375 O.D. X 0.065 WALL (REF. DART SPEC M304TR0.375W.065)
D3589-3: 0.500 O.D. X 0.058 WALL (REF. DART SPEC M304TR0.500W.058)
D3589-5: 0.500 O.D. X 0.049 WALL (REF. DART SPEC M304TR0.500W.049)
- 2) FINISH: NONE
- 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) UNITS: INCHES UNLESS OTHERWISE NOTED
- 5) BREAK SHARP EDGES: 0.005 TO 0.010 MAX
- 6) IDENTIFICATION: N/A
- 7) WEIGHT: - D3589-1 = 0.34 lbs
- D3589-3 = 0.01 lbs
- D3589-5 = 0.06 lbs

PROTOTYPE
PLEASE RETURN ALL ISSUED
DATA TO ENGINEERING

13 06-06-07

DESIGN		DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA	
DRAWN			
CHECKED		DRAWING NO. D3589	REV. A
MFG. APPR.			SHEET 4 OF 8
APPROVED		TITLE LATCH ASSEMBLY	SCALE NTS
DE APPR.			
DATE	08.05.29	COPYRIGHT © 2008 BY DART AEROSPACE LTD <small>THIS DOCUMENT IS PRIVATE AND CONFIDENTIAL AND IS SUPPLIED ON THE EXPRESS CONDITION THAT IT IS NOT TO BE USED FOR ANY PURPOSE OR COPIED OR COMMUNICATED TO ANY OTHER PERSON WITHOUT WRITTEN PERMISSION FROM DART AEROSPACE LTD.</small>	

Date: Thursday, 6/5/2008 1:05:15 PM
 User: David Duval

Process Sheet

Customer	: CU-DAR001 Dart Helicopters Services	Drawing Name	: ARM
Job Number	: 05030		
Estimate Number	: 13350		
P.O. Number	:	Part Number	: D35891
This Issue	: 6/5/2008 S.O. No. :	Drawing Number	: D3589 PROTO
Prsht Rev.	: NC	Project Number	: VR0004
First Issue	: / / Type : R & D SM/MED FAB	Drawing Revision	: PROTO
Previous Run	:	Material	:
Written By	: <u>MO8/06/05</u>	Due Date	: 6/12/2008 Qty: 2 Utn: Each
Checked & Approved By	:		
Comment	: Est Rev:A 08-05-29 new issue DD verified by:EC		

Additional Product

PROTOTYPE

Job Number:



FOR ENGINEERING USE ONLY

Seq. #: Machine Or Operation: Description:

1.0 M304TR0375W065 304 RD Tube .375 x .065W



Ynarmen P/O: 2008892



Comment: Qty.: 1.6520 f(s)/Unit Total: 3.3039 f(s)

304 RD Tube .375 x .065W

batch: M18993

FF 08-06-05

②

2.0 SMALL FAB 1 SMALL & MEDIUM FAB RESOURCE 1



Comment: SMALL & MEDIUM FAB RESOURCE 1

1- cut D3589-1 as per dwg D3589

2- deburr both ends as per dwg D3589

FF 08-06-05

②

3.0 QC5 INSPECT WORK TO CURRENT STEP

ENGINEERING
APPROVAL

Comment: INSPECT WORK TO CURRENT STEP

4.0 PACKAGING 1 PACKAGING RESOURCE #1



FOR ENGINEERING USE ONLY

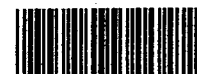


Comment: PACKAGING RESOURCE #1

Identify and Stock

Location: _____

5.0 QC21 FINAL INSPECTION/W/O RELEASE



Comment: FINAL INSPECTION/W/O RELEASE

Job Completion



charge to w/p #00224

Receiving Report

Date: 05/11/07
 Supplier: MARMON/KEYSTONE

Batch No: 18993
 Dart P/O: 2008892

Packing Slip: Yes ☒ No ☐
 Invoice: Yes ☐ No ☒
 Receipt: Cash ☐ Cr. ☐

Release Note Attached: Yes ☒ No ☐ N/A ☐
 Waybill Attached: Yes ☒ No ☐
 Shipment Complete: Yes ☒ No ☐
 Q.C. Inspection 36 05-11-07

Discrepancies

Part No.	Description	Quantity Ordered	Quantity Received	Quantity Returned	Quantity Short	Comments

TSR No. _____

Initials of receiver (if shipment OK) UCZ

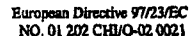
Production/Admin:
 Date 05/11/07
 Received/Costing KC2103
 Initial AP 2008892
 H:\ISO9000\Forms\Purchase\RECREPORT rev B

Accounting:
 Date _____
 AP/MR _____
 Initial _____



CHANGSHU WALSIN SPECIALTY STEEL CO., LTD. EN ISO9001

DN EN ISO9001
NO. 09 100 81166



2005/01/27


CONDITION: COLD FINISHED, ANNEALED, PICKLED, PLAIN END

CERTIFICATE NO.: 200501298024009

COMMODITY: STAINLESS STEEL COLD FINISHED SEAMLESS TUBE

GRADE: TP316/316L

CHEMICAL COMPOSITION (WT%)

REMARK: AS PER ASTM A213-01a/ASME SA213-01a PO#EN8469 LENGTH:20FT RB: 80 MAX MADE IN CHINA 400# POLISHED	1. WE HEREBY CERTIFY THAT THE MATERIAL DESCRIBED HEREIN BEEN MADE IN ACCORDANCE WITH THE RESULTS OF THE CONTRACT, AND CONFORM TO THE SPECIFICATION ABOVE. 2. THE CERTIFICATE SHALL NOT BE REPRODUCED EXCEPT IN FULL WITHOUT THE WRITTEN APPROVAL OF THE COMPANY.
<div data-bbox="263 1092 504 1112" style="border: 1px solid black; padding: 5px; display: inline-block;"> QIC REVIEWED FEB 15 2005 </div>	<div data-bbox="1098 1092 1412 1112" style="text-align: center;">  DIRECTOR , TECHNOLOGY </div>

WLCB-QP-T24-06

SIS- .375- .065 -316L * J0409-139 * 1004626 * B06409 * 6/22/2003